

Date: Thursday, 26/06/2008 12:34:55 PM  
User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY  
Job Number : 40122 -2  
Estimate Number : 13280  
P.O. Number :  
This Issue : 26/06/2008 S.O. No. :  
Prsht Rev. : NC Part Number : D3674041  
First Issue : 1/1 Type : MACHINED PARTS Drawing Number : D3674 REV A  
Previous Run : 38788 Material : N/A  
Drawing Revision : A  
Written By : JLM 08-06-27 Due Date : 03/07/2008 Qty: 30 Um: Each  
Checked & Approved By :  
Comment : Est Rev:A New Issue 08-04-25 JLM Verified By:DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M174B1000X02000 1.250 x 2.00 17-4 SS Bar



Comment: Qty.: 0.5775 f(s)/Unit Total: 17.3250 f(s)

Material: 17-4 SS Bar per AMS 5604/5643

(M17-4-B1-000X02-000) 1.250" x 2.00"

Identify for D3121-111

Batch: M109457

NO MATL IN COMPUTER

JLM 08/10/03

32

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks: (1.000" x 2.000") 5.400" long

JLM 08/10/03

32

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3674-1 as per Folio FA732 and Dwg D3674 Identify as D3674-1

2-Debur

3-Scribe batch number

JLM 08/10/08 29

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JLM 08/10/08 29



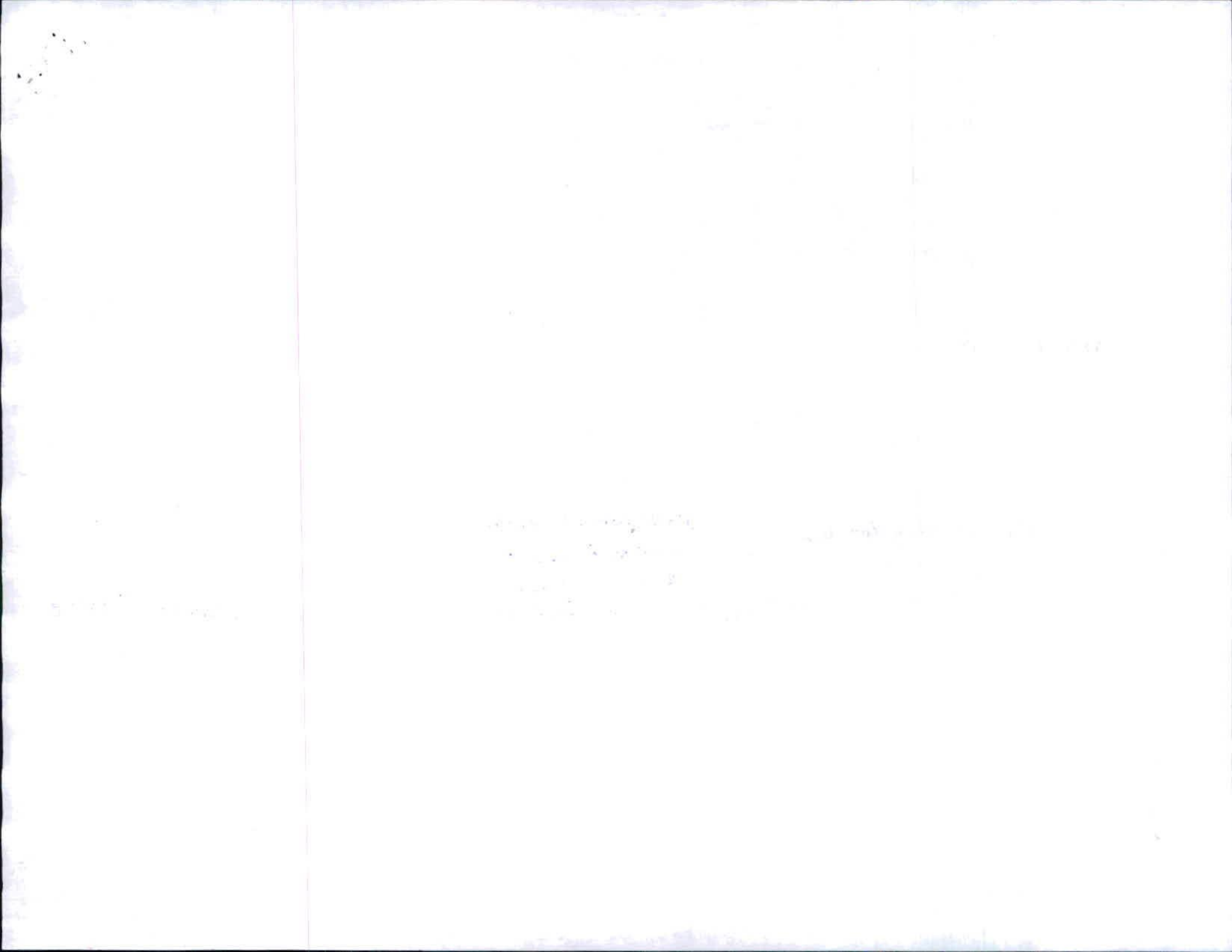
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: D3674-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: <u>40122</u> |      | WORK ORDER NON-CONFORMANCE (NCR)   |                             |  |                                |                           |                       |                                |
|-------------------|------|--|-----------------------------|--|--------------------------------|---------------------------|-----------------------|--------------------------------|
| DATE              | STEP | Description of NC<br>Section A   | Corrective Action Section B |  |                                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector       |
|                   |      |  | Initial<br>Chief Eng        | Action Description<br>Chief Eng  | Sign &<br>Date                 |                           |                       |                                |
| 08/10/08          | 3    | the engraving too deep.<br>R.C. first part run<br>raise the tool for next part | <i>[Signature]</i>          | Folio noted i: fixed.<br>- scrap i: destroy<br>- replace Qty 1<br>same batch # | <i>[Signature]</i><br>08/10/08 | H.A.<br>08/10/08          | <i>[Signature]</i>    | <i>[Signature]</i><br>08-10-08 |
|                   |      |  |                             |  |                                |                           |                       |                                |
|                   |      |  |                             |  |                                |                           |                       |                                |

NOTE: Date & initial all entries





## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 40122

Part Number: D3674041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



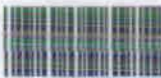
Comment: SECOND CHECK

26 08/10/09

6.0

D312121

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-21

Bolt B40284

26 08/10/09

7.0

D3121241

Bearing Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-241 Bearing Ass

B39948-2

26 08/10/09

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble D3121-141 as per Dwg D3121.

26 08/10/09 (29x)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

26 08/10/09 (29x) counter

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 238A

8/10/09

29x

11.0

QC21

FINAL INSPECTION/W/O RELEASE



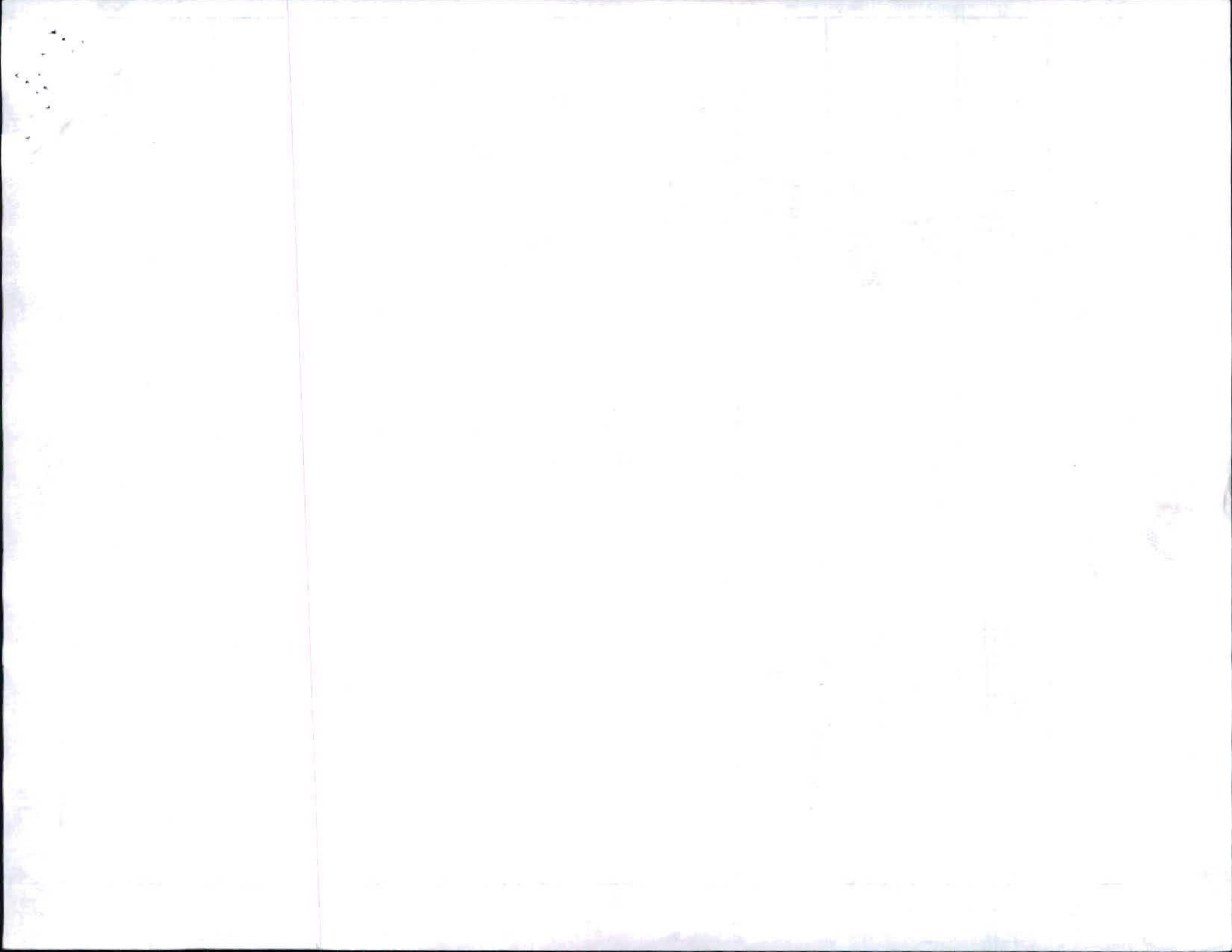
Comment: FINAL INSPECTION/W/O RELEASE

26 08/10/09

Job Completion



MF 08-10-09





|                                      |  |                                |
|--------------------------------------|--|--------------------------------|
| <b>DART AEROSPACE LTD</b>            |  | <b>Work Order:</b> 40122       |
| <b>Description:</b> roller bracket   |  | <b>Part Number:</b> D3674-04-1 |
| <b>Inspection Dwg:</b> D3674, Rev: A |  | Page 1 of 1                    |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 1.960             | + .010    | 1.965            | ✓      |        |                      |          |
| .750              | + .010    | .750             | ✓      |        |                      |          |
| .605              | + .010    | .607             | ✓      |        |                      |          |
| 3.380             | + .010    | 3.380            | ✓      |        |                      |          |
| 2.430             | + .010    | 2.430            | ✓      |        |                      |          |
| .380              | + .010    | .380             | ✓      |        |                      |          |
| 3°                | + 1/2°    | 3°               | ✓      |        |                      |          |
| .950              | + .010    | .951             | ✓      |        |                      |          |
| 2.030             | + .010    | 2.033            | ✓      |        |                      |          |
| 2.140             | + .010    | 2.142            | ✓      |        |                      |          |
| .720              | + .010    | .718             | ✓      |        |                      |          |
| Ø .573            | + .010    | .573             | ✓      |        |                      |          |
| Ø .392            | + .002    | .3928            | ✓      |        |                      |          |
| .300              | + .010    | .299             | ✓      |        |                      |          |
| .080              | + .010    | .079             | ✓      |        |                      |          |
| 5.25              | + .030    | .250             | ✓      |        |                      |          |
| 4.590             | + .010    | 4.584            | ✓      |        |                      |          |
| .130              | + .010    | .131             | ✓      |        |                      |          |
| .076              | + .010    | .073             | ✓      |        |                      |          |
| .200              | + .010    | .200             | ✓      |        |                      |          |
| .032              | + .010    | .028             | ✓      |        |                      |          |
| Ø .20(x 100)      | + .010    | Ø .200(x 100)    | ✓      |        |                      |          |

|                          |
|--------------------------|
| <b>Measured by:</b> J.L. |
| <b>Date:</b> 08/10/05    |

|                       |
|-----------------------|
| <b>Audited by:</b> SS |
| <b>Date:</b> 08/10/05 |

|                                |
|--------------------------------|
| <b>Prototype Approval:</b> N/A |
| <b>Date:</b>                   |

| Rev | Date | Change    | Revised by              | Approved |
|-----|------|-----------|-------------------------|----------|
| A   |      | New Issue | P/O D3674-041<br>KJ/JLM |          |

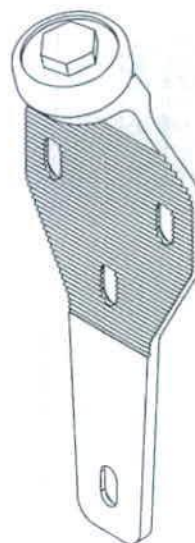
100-411

50

11



| QTY<br>-041 | PART NUMBER | DESCRIPTION             |
|-------------|-------------|-------------------------|
| X           | D3674-041   | ROLLER BRACKET ASSEMBLY |
| 1           | D3121-21    | BOLT                    |
| 1           | D3121-241   | BEARING ASSEMBLY        |
| 1           | D3674-1     | BRACKET                 |



D3674-041 BRACKET ASSEMBLY

NO. 40132  
WORK ORDER  
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**NOTES:**

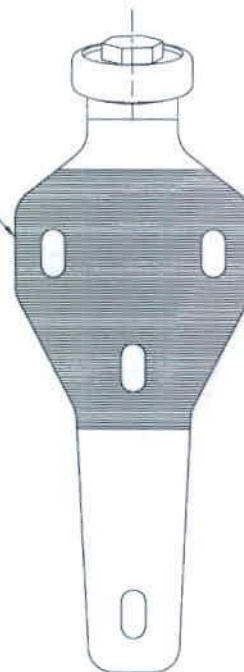
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs
- 8) TORQUE D3121-21 BOLT 15-25 in lbs (1.7-2.8 Nm)

RELEASED  
08-06-26

|            |             |  |              |
|------------|-------------|--|--------------|
| A          | NEW ISSUE   | AJS  | 08.03.26     |
| REV.       | DESCRIPTION | BY   | DATE         |
| DESIGN     | AJS         | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA  |              |
| DRAWN      | ALB         |  |              |
| CHECKED    |             | DRAWING NO.  | REV. A       |
| MFG. APPR. |             | D3674  | SHEET 1 OF 4 |
| APPROVED   |             | TITLE  | SCALE        |
| DE APPR.   |             | ROLLER BRACKET ASSEMBLY  | NTS          |
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D3674-1 BRACKET



D3674-041 BRACKET ASSEMBLY

D3121-21 BOLT

D3121-241 BEARING ASSEMBLY



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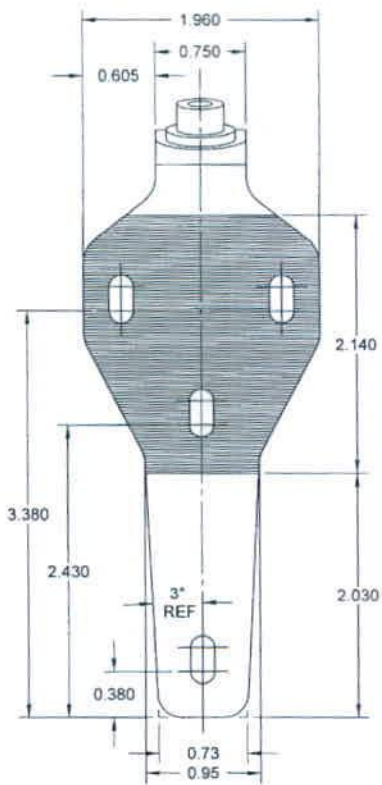
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08-06-76

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| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA   |              |
| CHECKED    |          | DRAWING NO.   | REV. A       |
| MFG. APPR. |          | D3674   | SHEET 2 OF 4 |
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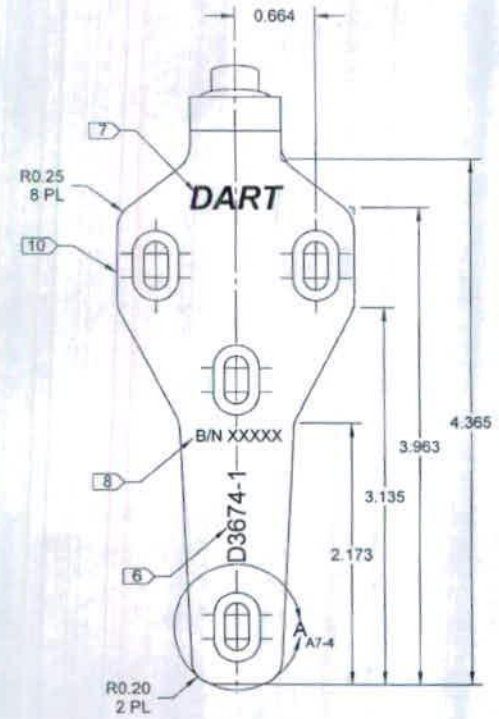
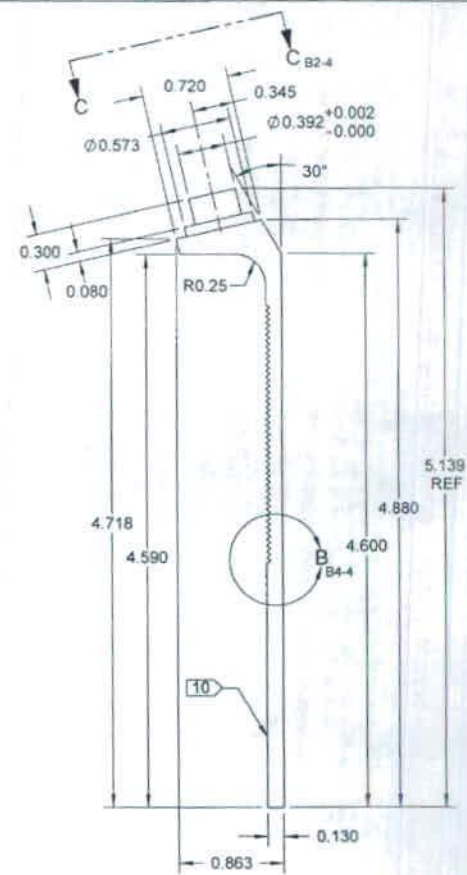




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**D3674-1 BRACKET**



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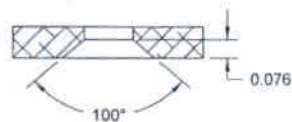
- 1) MATERIAL: 17-4 PH, STAINLESS STEEL BAR  
PER AMS 5604/5643  
GRAIN DIRECTION MUST BE ALONG THE LENGTH OF THE BRACKET  
MINIMUM YIELD TENSILE STRENGTH = 100 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 150 ksi  
(REF. DART SPEC. M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3674-1" WITH 0.15 HIGH LETTERS TO A  
MAX DEPTH OF 0.010 IN AREA SHOWN
- 7) IDENTIFICATION: ENGRAVE DART LOGO WITH 0.20 HIGH LETTER TO A  
MAXIMUM DEPTH OF 0.010 IN AREA SHOWN
- 8) IDENTIFICATION: SCRIBE DART B/N USING VIBRATING STYLUS
- 9) WEIGHT: 0.03 lbs
- 10) BASIC PROFILE OF D3674-1 BRACKET TAKEN FROM D3121-141 REF.

RELEASED  
26-06-2012

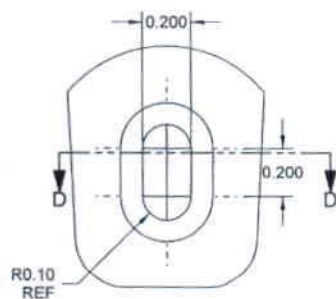
|  |          |  |              |
|--|----------|--|--------------|
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| MFG APPR.  |          | D3674                                  | SHEET 3 OF 4 |
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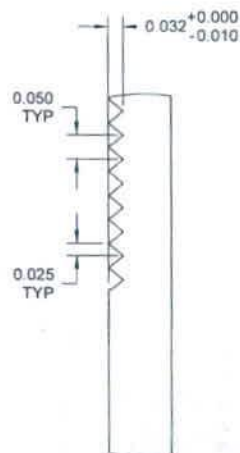




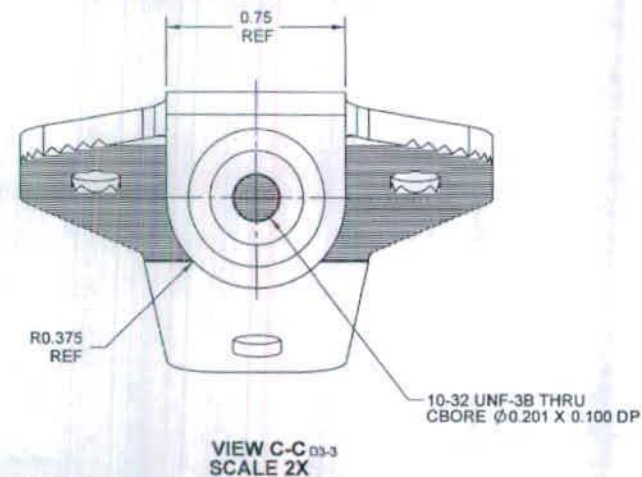
SECTION D-D



DETAIL A B2-3  
SCALE 2X  
(SLOT DETAIL 4PL)



DETAIL B C4-3  
SCALE 4X  
(RIDGE DETAIL)



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